

Date: Thursday, 10/18/2007 7:58:51 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	ANGLE		
Job Number	35188		Part Number	D314085		
Estimate Number	11459		Drawing Number	D3140 REV F		
P.O. Number	N/A		Project Number	N/A		
This Issue	10/18/2007	S.O. No. N/A	Drawing Revision	F		
Prsht Rev.	NC	Type	SMALL /MED FAB	Material	N/A	
First Issue	N/A			Due Date	10/24/2007	
Previous Run	34831		Qty:	4	Um:	Each
Written By						
Checked & Approved By	10/18/2007					
Comment	Est. A 02.04.30 New Issue NG Est. Rev B New dwg rev. ecn781 06.04.18 EC Est Rev:C As per ECN #829 06-11-20 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M5052H32S040	5052-H32 .040 Sheet	
	Comment: Qty.: 0.3688 sf(s)/Unit Total : 1.4750 sf(s) M5052H32S.040 SHEET Batch 10101525 M104921	SAD 07-11-01	
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Cut as per dwg D3140 26.65" long Deburr. Form as per Dwg D3140 No sharp edges] -Scuff surfaces with 80grit sandpaper per QSI 006 Contour as per dwg	SP 07/12/20 ⑥ SB 07/12/20 FF 07-12-20 SAD 07-10-10	⑥
3.0	QC5	INSPECT WORK TO CURRENT STEP	
	Comment: INSPECT WORK TO CURRENT STEP	SH 07/12/21 ⑥	⑥
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	PK 08-01-12 ⑥	⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 7:58:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 35188

Part Number: D314085

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-J

08/01/12

(6x)

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 143

8/1/14 SC0

(6x)

(b)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/01/15

Job Completion



6/24/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>4</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>J.D.H.</i>	APPROVED <i>J.D.H.</i>	DRAWING NO. D3140 REV. F SHEET 1 OF 7		
DATE 06.10.06		TITLE DOOR SCALE NTS		
A	02.04.18	NEW ISSUE		
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303		
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°		
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67		
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10		
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE		

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION	
X						D3140-05	DOOR	
	X					D3140-06	DOOR	
		X				D3140-07	DOOR	
			X			D3140-08	DOOR	
				1	X	D3140-09	DOUBLER ASSEMBLY	
					1	X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD	
1	1					D3140-59	PAD	
2	2					D3140-61	PAD	
2	2					D3140-63	PAD	
				1	1	D3140-69	PAD	
					1	D3140-71	PAD	
					1	D3140-73	PAD	
					1	D3140-75	PAD	
					1	D3140-77	PAD	
					1	D3140-79	PAD	
					1	D3140-85	ANGLE	SHOP COPY
1	1					D3140-87	DOUBLER	RETURN TO
					1	D3140-89	DOUBLER	ENGINEERING
					1	D3140-91	DOUBLER	UNCONTROLLED COPY
					1	D3140-92	DOUBLER	SUBJECT TO AMENDMENT
3	3					D3140-95	DOUBLER	WITHOUT NOTICE
1						D3140-97	DOUBLER	WORK ORDER
	1					D3140-98	DOUBLER	NO 35188
					1	D3140-99	DOUBLER	
				2	2	D3140-101	DOUBLER	
				1		D3140-103	DOUBLER	
					1	D3140-104	DOUBLER	
					1	D3140-105	DOUBLER	
					1	D3140-106	DOUBLER	
1	1					D3140-241	DOUBLER	
1				1		D3140-301	DOUBLER	
	1			1		D3140-303	DOUBLER	
					5	MS20426AD3-4	RIVET	



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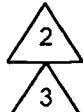
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CHECKED <i>J.D.</i>	APPROVED <i>#</i>	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
 MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
 MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
 FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED06-11-13 *#*

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION



RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

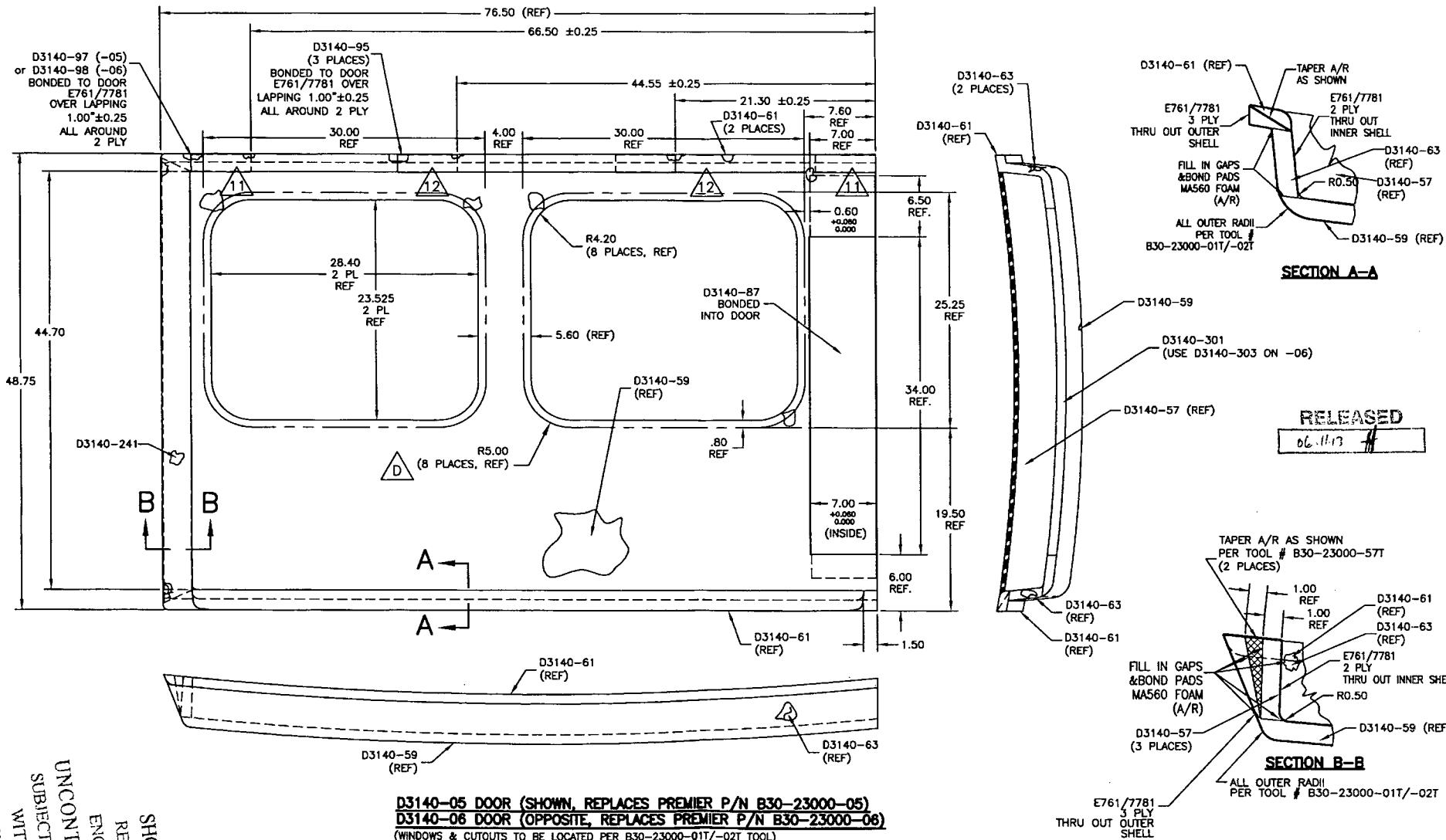


PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
 ALODINE PER DART QSI 005 4.1

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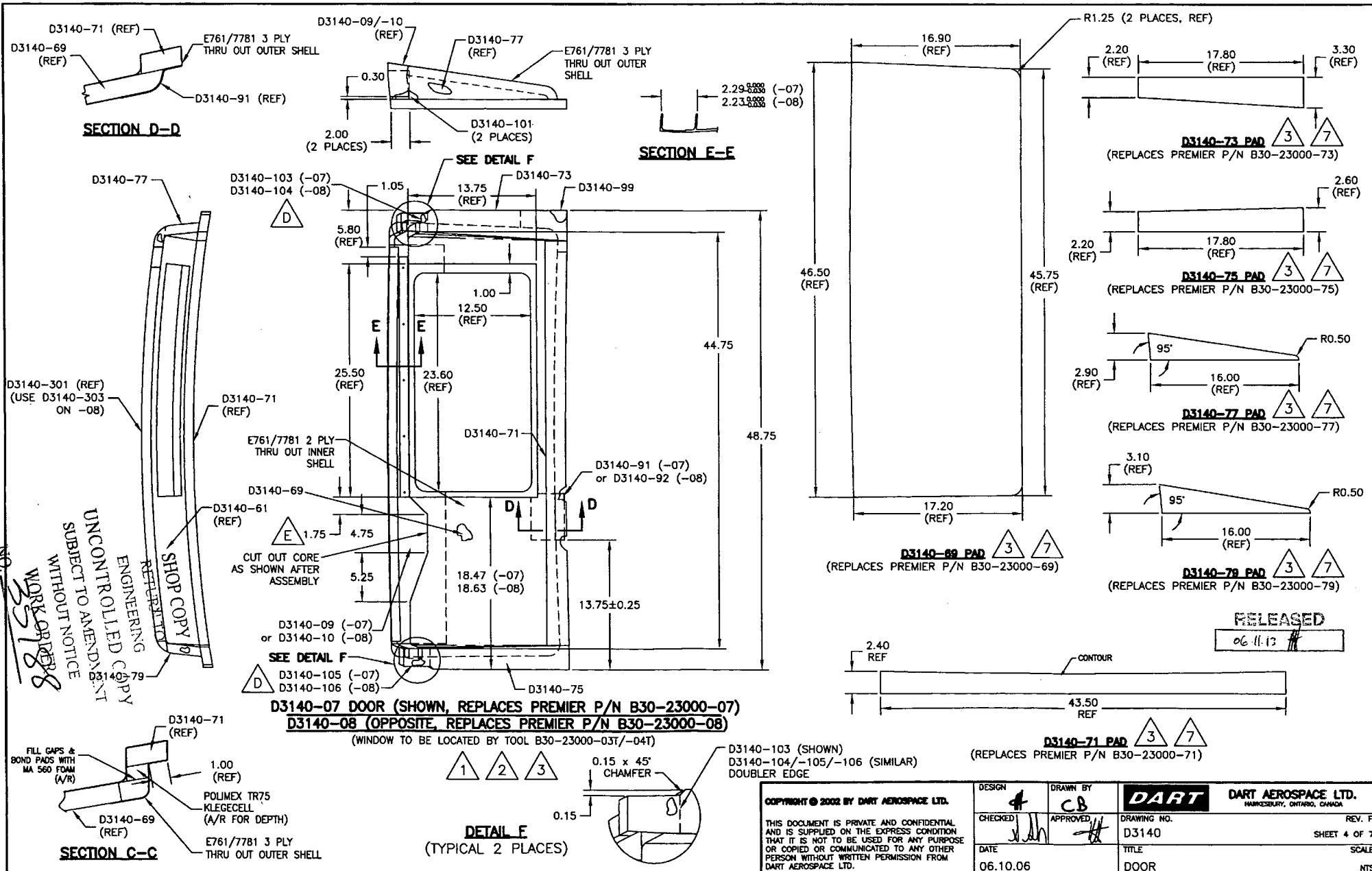
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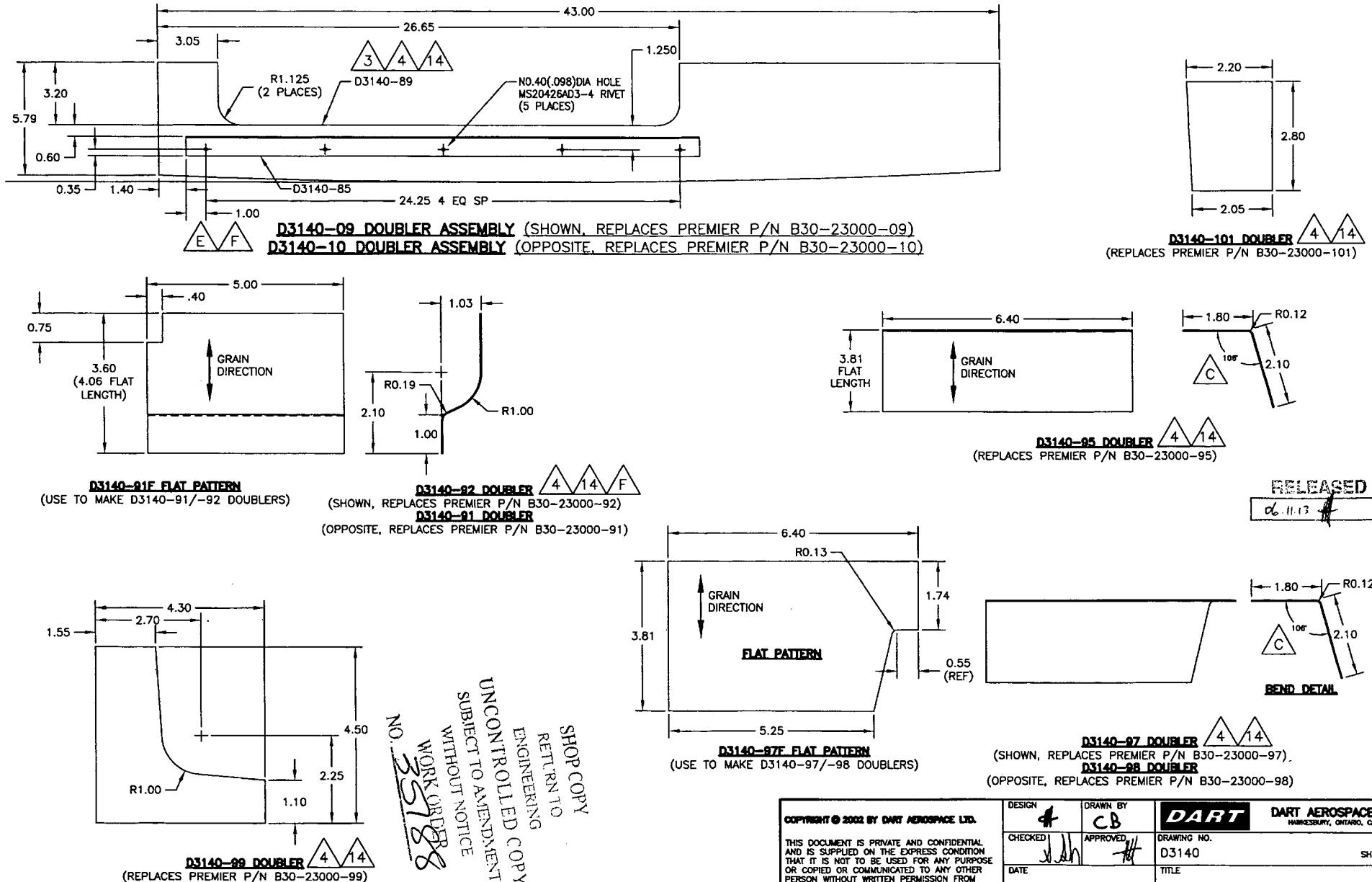
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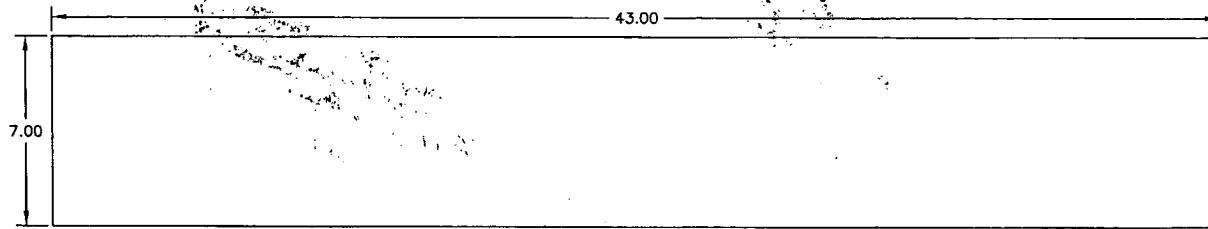
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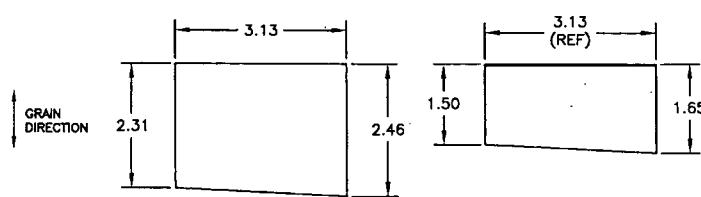
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CHECKED	APPROVED		REV. F
DATE		DRAWING NO. D3140	SHEET 3 OF 7
06.10.06		TITLE DOOR	SCALE NTS



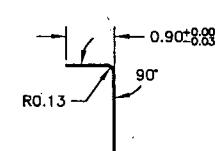




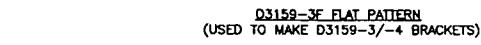
D3140-87 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-87)



D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



D3140-105 DOUBLER
D3140-106 OPPOSITE



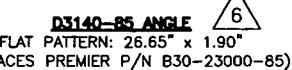
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)

48.59 (REF)

48.57 (REF)

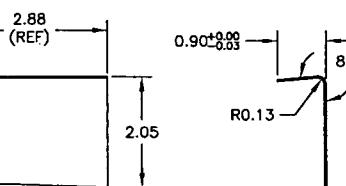
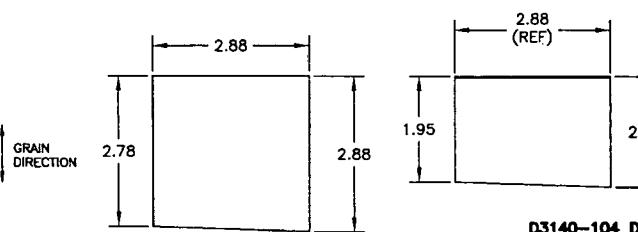


26.65
CONTOUR PER DOOR

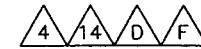


D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

1.00
R0.125
1.00
No.
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D3140-108



D3140-104 DOUBLER
D3140-103 OPPOSITE



D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

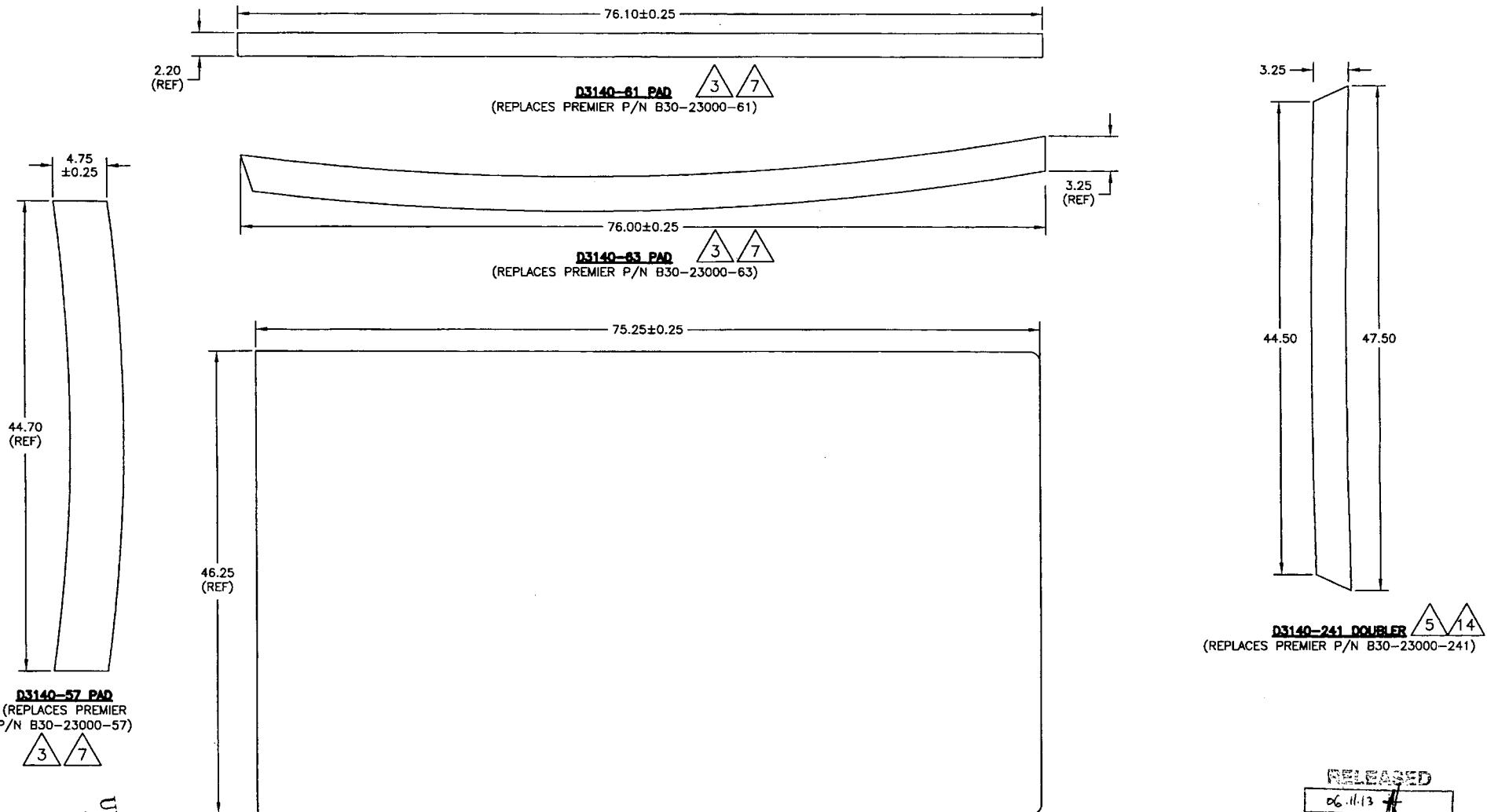
RELEASED

06.11.13

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4	CB		REV. F
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		D3140	SCALE
DATE		TITLE	NTS
06.10.06		DOOR	



D3140-59 PAD 7
(REPLACES PREMIER P/N B30-23000-59)

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DATE		06.10.06	TITLE	DOOR	NTS